

08649



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C60-K **Job Sheet 192147**

**Part No:** C60-K**Job Qty:** 1 pcs**Part Name:** C-Series Remote Hook 6,000 lbs Lift Capacity**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/18/19**Job Tracking No:****Due Date:** 5/2/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:** order 14505**Note:** DWG C60-K Rev.2 IPP Rev. A 19.03.01 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 1	1 pcs	5/2/19		0.00	0.10	External Load - 1		AD
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	5/2/19		0.00	1.00	External Load - 1 - B4B		AP 2019/05/07 Michel
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	5/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	Packaging 3-2 - Stock - B4B	1 pcs	5/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165819**Part:** C60 - K**Job No:** 192147**Serial No/Batch:** S165819**Revision:** 2**Inspector:****Exp Date:****Instructions:****Date:** 03/25/19

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				Packaging 3 - 8 - B4B	9-89 30 DAS
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	5/2/19	0.00 0.00	QC 21 - FG - 21	21 27 9-89
				QC 21 - FG - 70	
				QC 21 - FG - 53	

MAY 07 2019

Part Op 100 - Issue S/N.

Descriptions: 110 - 1- PICK C60-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 4 ON SHEET 3. 2- ASSEMBLE AS PER DWG 3- PERFORM ALL NECESSARY TEST USING FAI TEST SHEET.

120 - QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1/4-20-3/8	Set Screw	2 Ea (2 ea)	100-External Load - 1	5048557
188-FSCS-1032-5/8	Set Screw	4 Ea (4 ea)	110-External Load - 2 - B4B	5047611
2595K2 785K75	Heat Shrink	1 ft (1 ea)	110-External Load - 2 - B4B	5134207
32448	16-14 AWG Knife Connector	3 Ea (2 ea)	110-External Load - 2 - B4B	5151100
600.1309	CANAM Plate ID Label	1 pcs (1 ea)	110-External Load - 2 - B4B	
600.1309-A	Label	1 pcs (1 ea)	110-External Load - 2 - B4B	
AN4-20A 247	Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	5123434
AN5-21A	Bolt	4 Ea (4 ea)	110-External Load - 2 - B4B	5097081
C10-41	Strain Relief Connector	1 Ea (1 ea)	110-External Load - 2 - B4B	5040662
C2-14-2	Label Rivets	2 Ea (2 ea)	110-External Load - 2 - B4B	
C45-1-1	Manual Knob Release	1 pcs (1 ea)	110-External Load - 2 - B4B	5131790
C45-10-1	Lock Spring Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5029293
C45-11-2	Locating Pin	2 Ea (2 ea)	110-External Load - 2 - B4B	5089115
C45-12-1	Lock Bushing	2 pcs (2 ea)	110-External Load - 2 - B4B	5163187
C45-12-2	Lock Shaft	1 pcs (1 ea)	110-External Load - 2 - B4B	5163665
C45-12-4	Lock Roller	1 pcs (1 ea)	110-External Load - 2 - B4B	5108073
C45-12-5	Lock Roller Pin	1 pcs (1 ea)	110-External Load - 2 - B4B	5093171
C45-12-6	Retaining Ring	2 Ea (2 ea)	110-External Load - 2 - B4B	5029303
C45-13-1	Keeper Bushing	2 pcs (2 ea)	110-External Load - 2 - B4B	5125630

5130326

C45-13-3	Keeper Shaft	1 Ea (1 ea)	110-External Load - 2 - B4B	5157825
C45-15	Keeperless Adapter	1 pcs (1 ea)	110-External Load - 2 - B4B	5123093
C45-3-11	Actuator	1 pcs (1 ea)	110-External Load - 2 - B4B	5165452
C45-3-12	Latch Roller Bearing	1 Ea (1 ea)	110-External Load - 2 - B4B	5097903
C45-3-2	Latch Roller Pin	1 pcs (1 ea)	110-External Load - 2 - B4B	5029316
C45-3-2-1	Snap Ring	2 Ea (2 ea)	110-External Load - 2 - B4B	5029317
C45-3-3	Latch Roller	1 pcs (1 ea)	110-External Load - 2 - B4B	5127763
C45-3-4	Pin	2 pcs (2 ea)	110-External Load - 2 - B4B	5133668
C45-3-4-1	Retaining Ring	4 Ea (4 ea)	110-External Load - 2 - B4B	5114803
C45-3-5	Teflon Spacer	2 Ea (2 ea)	110-External Load - 2 - B4B	5029321
C45-3-6	Latch	1 pcs (1 ea)	110-External Load - 2 - B4B	5165726
C45-3-7	Link	1 pcs (1 ea)	110-External Load - 2 - B4B	5029322
C45-3-8A	Actuator Shaft Bushing	1 pcs (1 ea)	110-External Load - 2 - B4B	5078570
C45-3-8B	Actuator Shaft Bushing	1 pcs (1 ea)	110-External Load - 2 - B4B	5078801
C45-3-9	Lever Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5089520
C45-4-1	Trunnion Bushing	2 pcs (2 ea)	110-External Load - 2 - B4B	5163245
C45-4-4KA	Load Beam Keeperless Assembly	1 pcs (1 ea)	110-External Load - 2 - B4B	5126464
C45-4-5	Loadbeam Spacer	1 pcs (1 ea)	110-External Load - 2 - B4B	5163562
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5029329
C45-5-2	Lever Stop	1 pcs (1 ea)	110-External Load - 2 - B4B	5029330
C45-7-1	LOADBEAM BUMPER	1 pcs (1 ea)	110-External Load - 2 - B4B	5156421
C45-7-2	Lock Bumper	2 pcs (2 ea)	110-External Load - 2 - B4B	5163721
C45-8-1-2	Solenoid Nut	2 pcs (2 ea)	110-External Load - 2 - B4B	5163995
C45-8-2	Solenoid	1 pcs (1 ea)	110-External Load - 2 - B4B	5163956
C45-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	110-External Load - 2 - B4B	5171779
C45-8-5	Solenoid Cover	1 pcs (1 ea)	110-External Load - 2 - B4B	5095491
C45-9-1	Clock Spring Cover	1 pcs (1 ea)	110-External Load - 2 - B4B	5029337
C45-9-2	Clock Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5107946
C60-10-2	Lock Spring	1 pcs (1 ea)	110-External Load - 2 - B4B	5076648
C60-11-1	Side Plate Solenoid	1 pcs (1 ea)	110-External Load - 2 - B4B	5062199
C60-12-3	Lock	1 pcs (1 ea)	110-External Load - 2 - B4B	5029342
C60-2-1	Side Plate	1 pcs (1 ea)	110-External Load - 2 - B4B	5029450
C60-3-1	Radial Bearing	2 Ea (2 ea)	110-External Load - 2 - B4B	5093409
C60-3-10	Latch Shaft	1 pcs (1 ea)	110-External Load - 2 - B4B	5029345
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-External Load - 2 - B4B	5164040
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge	1 ft (1 ea)	110-External Load - 2 - B4B	5159774
MS21044N5	Nut	4 Ea (4 ea)	110-External Load - 2 - B4B	5097089
MS27039-4-08	Screw	1 Ea (1 ea)	110-External Load - 2 - B4B	5039330
NAS1149F0563P	Washer	8 Ea (8 ea)	110-External Load - 2 - B4B	5098031-1
NAS1149F0632P	Washer	3 Ea (3 ea)	110-External Load - 2 - B4B	5067038

5078780

Lactite 242 (M138933)

Lactite 620 (S166705)

Aeroshell grease no.7 (M138724)

Saf-t-eye (M128063)

5159114

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	188-FPSS-1/4-20-3/8	2	122	0
110-External Load - 2 - B4B	188-FSCS-1032-5/8	4	82	0
	2595K2	1	19	0
	32448	2	219	0
	600.1309	1	0	0
	600.1309-A	1	94	0
	AN4-23A	2	690	0
	AN5-21A	4	364	0
	C10-41	1	28	0
	C2-14-2	2	182	0
	C45-1-1	1	7	0
	C45-10-1	1	162	0
	C45-11-2	2	43	0
	C45-12-1	2	29	0
	C45-12-2	1	5	0
	C45-12-4	1	19	0
	C45-12-5	1	47	0
	C45-12-6	2	114	0
	C45-13-1-PB	2	0	0
	C45-13-3	1	8	0
	C45-15	1	2	0
	C45-3-11	1	5	0
	C45-3-12	1	86	0
	C45-3-2-P	1	0	0
	C45-3-2-1	2	93	0
	C45-3-3	1	25	0
	C45-3-4	2	60	0
	C45-3-4-1	4	165	0
	C45-3-5	2	99	0
	C45-3-6	1	4	0
	C45-3-7-P	1	0	0
	C45-3-8A	1	30	0
	C45-3-8B	1	17	0
	C45-3-9	1	31	0
	C45-4-1	2	30	0
	C45-4-4KA	1	2	0
	C45-4-5	1	4	0
	C45-5-1	1	46	0
	C45-5-2-P	1	0	0
	C45-7-1	1	18	0
	C45-7-2	2	4	0
	C45-8-1-2	2	0	0
	C45-8-2	1	6	0
	C45-8-4	1	9	0
	C45-8-5	1	19	0
	C45-9-1-P	1	0	0
	C45-9-2	1	45	0
	C60-10-2	1	40	0
	C60-11-1-P	1	0	0
	C60-12-3-P	1	0	0
	C60-2-1-P	1	0	0
	C60-3-1	2	60	0
	C60-3-10-P	1	0	0
	EL-PLUG-M	1	33	0
	EL314-SJTOW	1	718	0
	MS21044N5	4	89	0
	MS27039-4-08	1	229	0
	NAS1149F0563P	8	417	0
	NAS1149F0632P	3	389	0

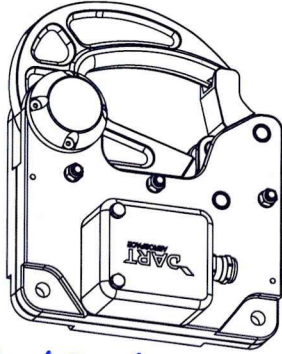
Part Specifications

Specifications could not be found.

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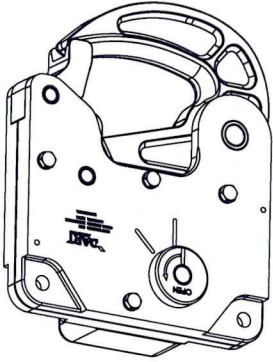
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QTY	ASSY	B/O	Part #	UNIT	Description	Material	PG.
1			C45-1-1		MANUAL KNOB RELEASE	6061	
2			C45-3-2		LATCH ROLLER PIN	O-1	
2			C45-3-1		SNAP RING	STEEL	
3			C45-3-3		LATCH ROLLER	4140/4142	
3			C45-3-4		LINK PIN	O-1	
4			C45-3-1		RETAINING RING	BERYLLIUM COPPER	
3			C45-3-5		SPACER	7174 S.S.	
3			C45-3-6		LATCH	1714 S.S.	
3			C45-3-7		LINK	O-1	
3			C45-3-8A		ACTUATOR SHAFT BUSHING	AL BRONZE 630	
3			C45-3-8B		ACTUATOR SHAFT BUSHING SOLENOID SIDE	AL BRONZE 630	
3			C45-3-9		LEVER SPRING	303 S.S.	
3			C45-3-11		ACTUATOR	1714 S.S.	
3			C45-3-12		DU BEARING	(KAMAN 06006)	
2			C45-4-1		TRUNNION BUSHING	AL BRONZE 630	
3			C45-4-2A		C45 LOAD BEAM KEEPERLESS ASSY.	4140/4142 Q&T	
3			C45-4-3		LOAD BEAM SPACER	STEEL	
1			C45-5-1		LEVER STOP PIN	1/4 X 1-3/8 (MCMMASTER-CARR #98381A545)	
2			C45-5-2		LEVER STOP	304 S.S.	
2			C45-7-1		LOAD BEAM BUMPER	POLYURETHANE	
2			C45-7-2		LOCK BUMPER	POLYURETHANE	
2			C45-8-1-2		SOLENOID NUT	304 S.S.	
1			C45-8-2		SOLENOID ASSY	(REF: H-2653-020)	
1			C45-8-5		SOLENOID COVER	6061	
1			C45-9-1		CLOCK SPRING COVER	6061	
1			C45-9-2		CLOCK SPRING	303 S.S.	
1			C45-10-1		SPRING PIN	1/4 X 1.0 (MCMMASTER-CARR #2373A183)	
2			C45-11-2		LOCATING PIN	S.S.	
2			C45-12-1		LOCK BUSHING	4140/4142	
1			C45-12-2		LOCK SHAFT	4140/4142	
1			C45-12-4		LOCK ROLLER	4140/4142	
1			C45-12-5		LOCK ROLLER PIN	4140/4142	
2			C45-12-6		RETAINING RING	(KAMAN #N1400-0050)	
3			C45-13-1		KEEPER BUSHING	4140/4142	
3			C45-13-3		KEEPER SHAFT	4140/4142	
1			C45-15		KEEPERLESS ADAPTER	4140/4142	
2			C60-2-1		SIDE PLATE	7075-T6	
2			C60-3-1		RADIAL BEARING	(KAMAN #1614 285)	
1			C60-3-10		LATCH SHAFT	1714 S.S.	
1			C60-10-2		LOCK SPRING	302 S.S.	
1			C60-11-1		SIDE PLATE SOLENOID	302 S.S.	
1			C60-12-3		LOCK	4140/4142	
1			C10-41		STRAIN RELIEF CONNECTOR	BRASS	
2			C2-14-2		LABEL RIVETS	18-8 S.S.	
1			6001309		LABEL	ALUMINUM	
1			6001309-A		LABEL	ALUMINUM	
2			40011909-A		BOLT	1/4-28 X 2.22	
3			AN560-21A		WASHER	STEEL	
6			AN560-516		WASHER	STEEL	
4			MS21044N5		LOCK NUT	5/16	
1			MS27039-4-08		BOLT	STEEL	
4			188-FPS-1032-518		SCREW	1/4-28 X .531	
1			ELUO-AM		MALE FLUG	S.S.	
2			314-1		WIRE	10-32 X 5/8 FINE (MCMMASTER-CARR #92210A303)	
2			32448		16-1 AVG KNIFE CONNECTOR	(EXCAN 314J10W 3/14)	
2			32448		HEAT SHRINK TUBE	(MCMMASTER-CARR #299472)	



NO. 192147 MS
192318

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NOTES:
FOR REBUILD ONLY.
FOR CUSTOMER REBUILD ONLY.

DART
AEROSPACE

C60-K-HOOK

C60-K

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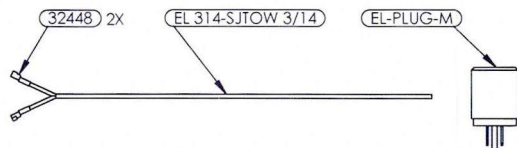
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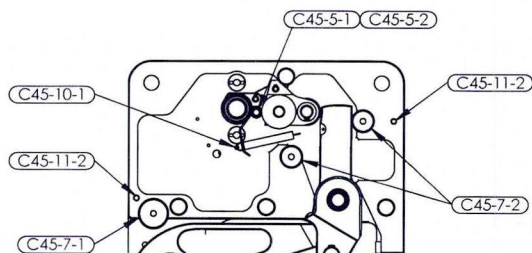
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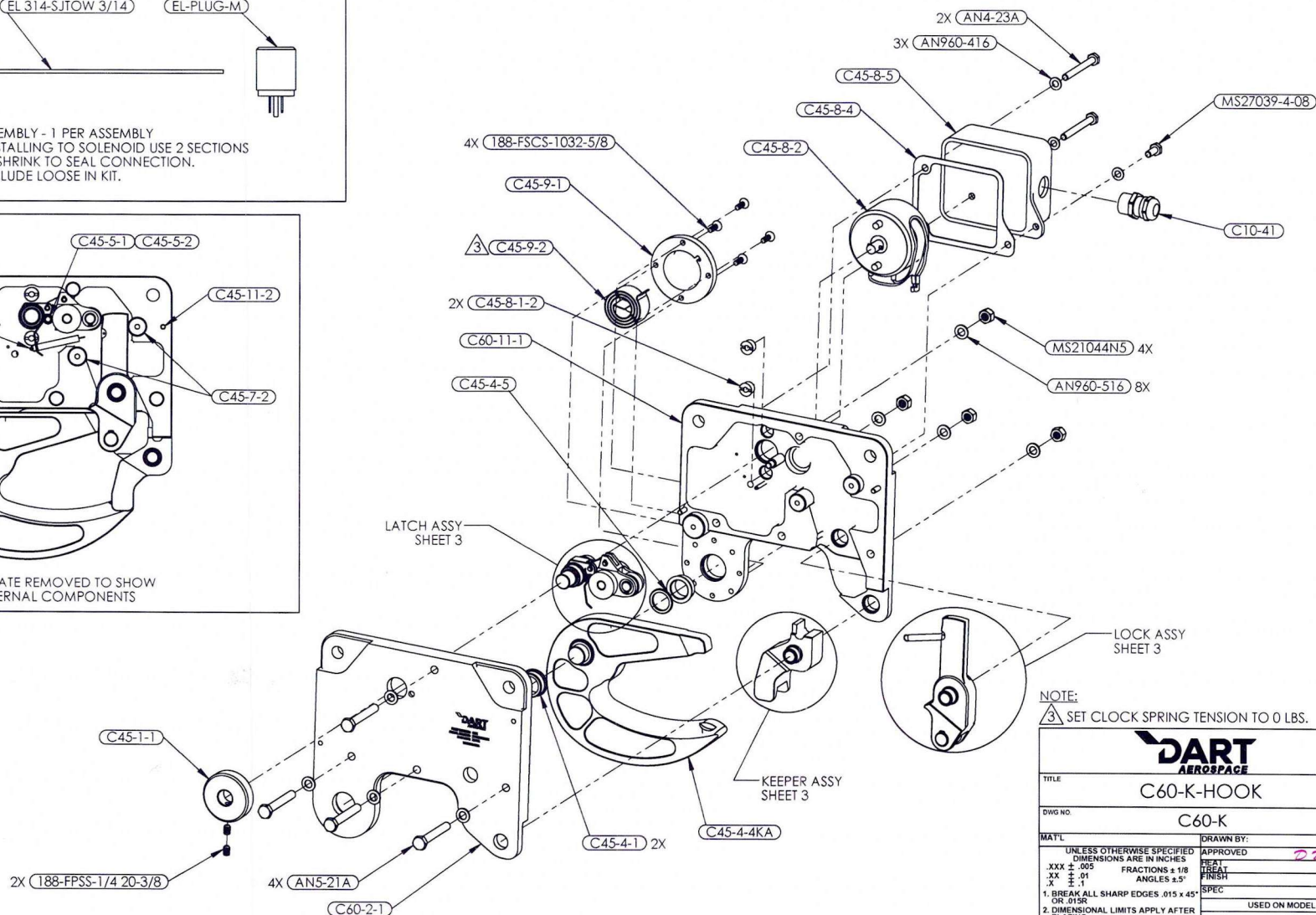
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WIRE ASSEMBLY - 1 PER ASSEMBLY
WHEN INSTALLING TO SOLENOID USE 2 SECTIONS
OF HEAT SHRINK TO SEAL CONNECTION.
PLUG INCLUDE LOOSE IN KIT.



SIDE PLATE REMOVED TO SHOW
INTERNAL COMPONENTS

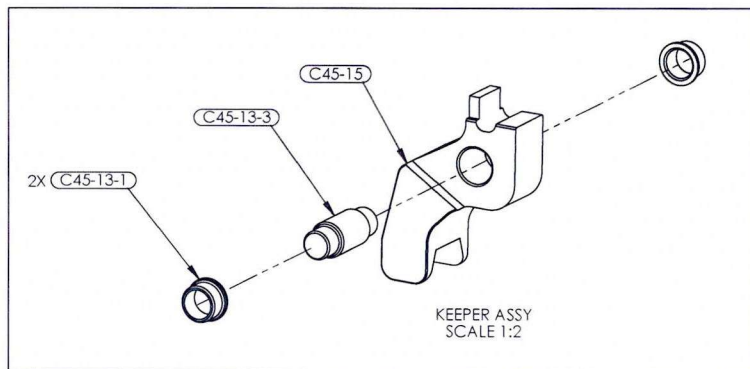


NOTE:
3. SET CLOCK SPRING TENSION TO 0 LBS.

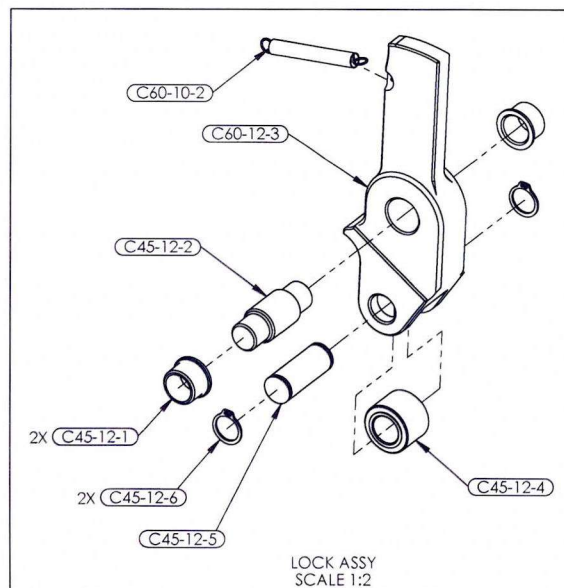
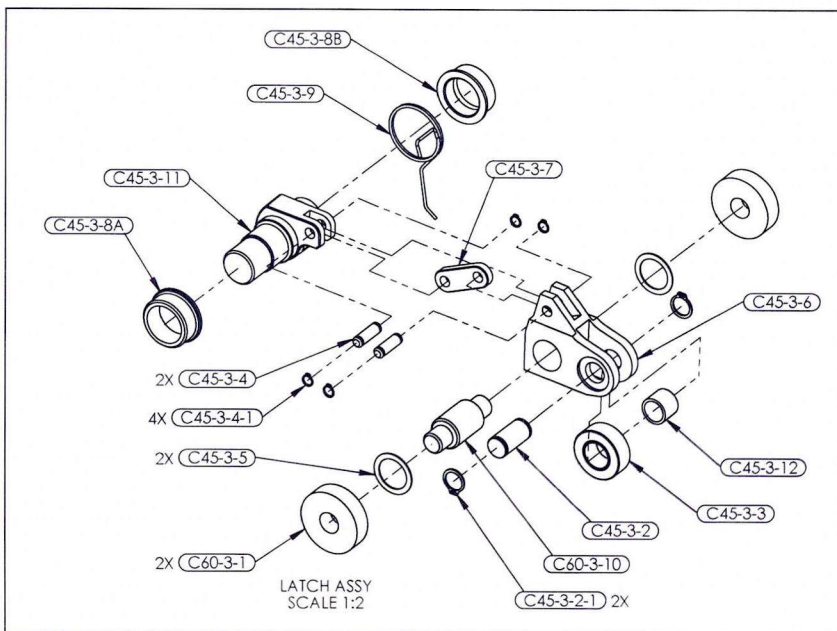
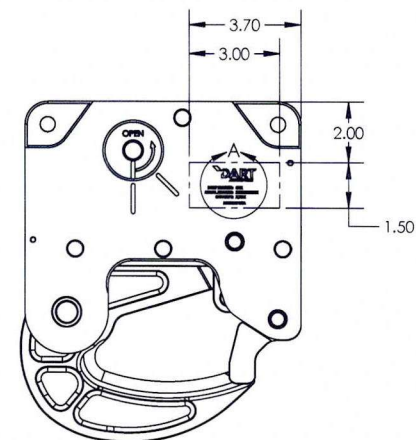
DART AEROSPACE	
TITLE C60-K-HOOK	
DWG NO. C60-K	REV 2
MATERIAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1	
DRAWN BY: APPROVED: <i>D. West</i>	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE SHEET 2 OF 3

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



DETAIL A
SCALE 1 : 1



NOTE:
4 LASER ENGRAVE DART LOGO, P/N, S/N, "MADE IN USA," WITHIN BOUNDARY.

DART AEROSPACE	
TITLE C60-K-HOOK	
DWG NO.	REV 2
C60-K	
MAT'L	DRAWN BY: <i>D. Weil</i>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	APPROVED SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE
SHEET 3 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Work Order 192 147Customer 14505Serial Number 5165819Date 2019-4-22

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/fail
1	15,000	Static Hold	Hold for two Minutes and reduce load to zero	N/A	Pass
10	3,000	Electircal, 25 volts	No "hang ups" permitted	N/A	Pass
2	6,000	Electircal, 22 volts	Current shall not exceed 12.4A	9.0 Amp.	Pass
2	4,500	Electircal, 22 volts	Current shall not exceed 12.4A	8.7 Amp.	Pass
2	3,000	Electircal, 22 volts	Current shall not exceed 12.4A	8.5 Amp.	Pass
2	1,500	Electircal, 22 volts	Current shall not exceed 12.4A	8.2 Amp.	Pass
2	500	Electircal, 22 volts	Current shall not exceed 12.4A	8.5 Amp.	Pass
1	6,000	Electircal, 20 volts	Current shall not exceed 11.3A	7.8 Amp.	Pass
1	6,000	Electircal, 28 volts	Current shall not exceed 15.8A	10.2 Amp.	Pass
1	6,000	Manual		N/A	Pass
1	6,000	Impact Test	Impact shackle 10 times, shall not release	N/A	Pass
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ohms	2.0 Ohms	Pass
1	N/A	Electircal Continuity	Across both wires	N/A	Pass

Test Conducted By Michel LalondeSignature: Sylvie Pancher
QC 5/Small FAB / QA**Submit**